

rust

ship Oct 28

Work Order ID 152363

152363

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Friday, October 21, 2016 4:22:46 PM

Item ID: D3136-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Window Assembly
 Start Date: 10/24/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 10/28/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: *em* Date: *10/10/21* Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3136	F								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.15							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <i>F</i> Prog Rev: <i>F</i> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.02							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.03							
Quality Control									

10 *on 10/10/24*

10 *on 10/10/24*

10 *DAS 38 OCT 24 2016*

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NS1

NS2

NR1

NR2

Water sand and buff to remove scratches as required

DAS
07
9-89

16/10/26

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Stop *NR2*

DAS OCT 27 2016
21
9-89

Picklist Print

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Work Order ID: 152363

152363

Parent Item: D3136-045

D3136-045

Parent Item Name: Window Assembly

Start Date: 10/24/2016

Required Date: 10/28/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:C 15.02.13 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3108-9

Manufactured

No

Each

161.0000

20

D3108-9

DAS
07
9-89

Decal

Location

Loc Qty

Loc Code

ST017

161

138645

161

MACRLICS.125

Purchased

No

sf

104.6500

44.73684

MACRI ICS 125

1/8" Polycast II Sheet

Location

Loc Qty

Loc Code

MAT019

104.65

m131524

8.95

m134641

12

m135555

83.7

**MACRLICS.125
M135555**

10/10/26

20 ea

50

216/10/24

5

45

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY

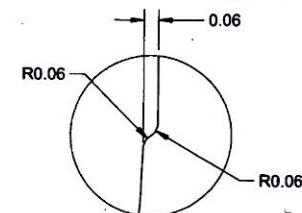
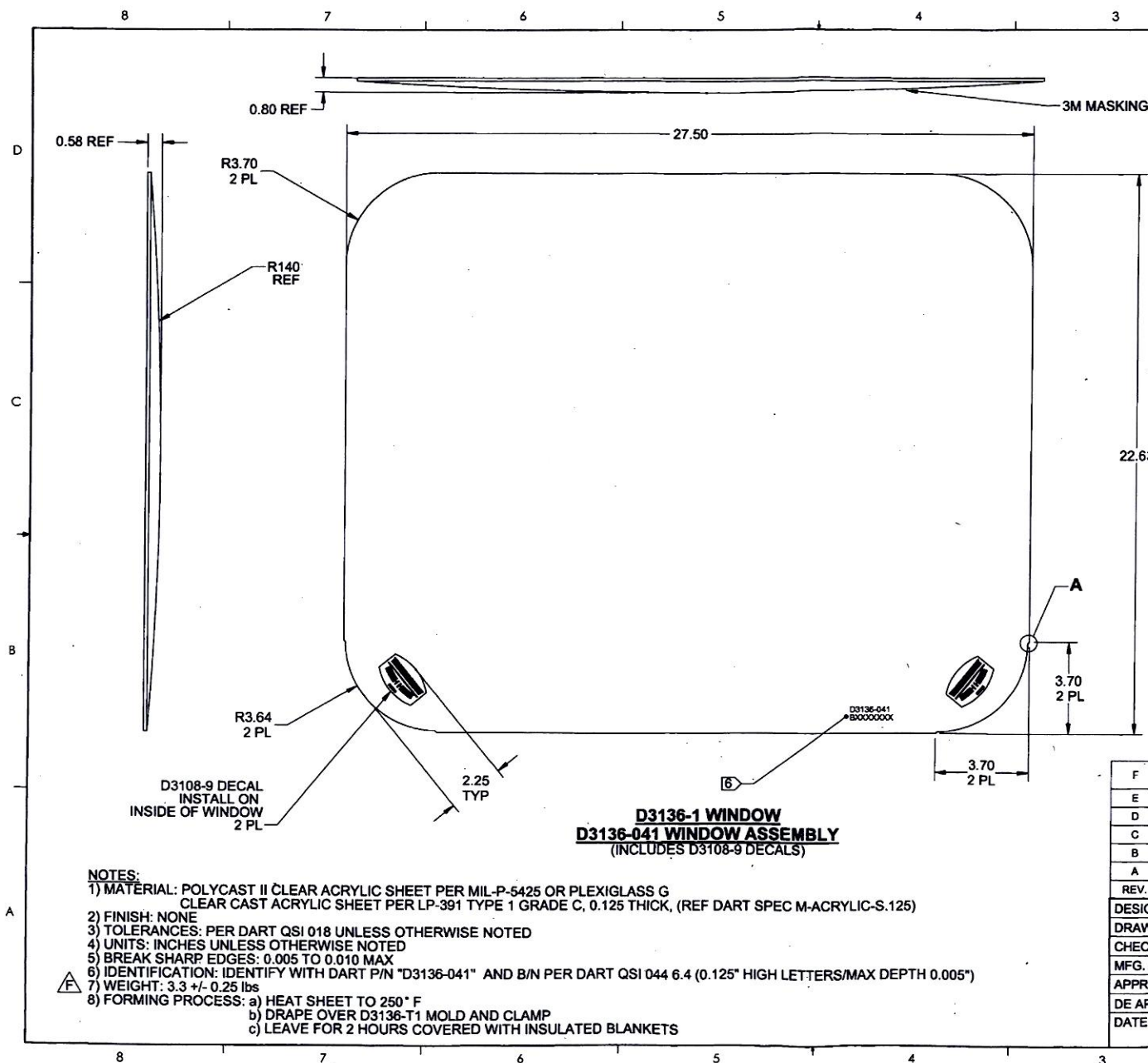
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 152363

2m 16/10/21



DETAIL A
SCALE 8X
4 PL

RELEASED
2015-01-12

**D3136-1 WINDOW
D3136-041 WINDOW ASSEMBLY**
(INCLUDES D3108-9 DECALS)

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLASS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK, (REF DART SPEC M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3136-041" AND B/N PER DART QSI 044 6.4 (0.125" HIGH LETTERS/MAX DEPTH 0.005")
- 7) WEIGHT: 3.3 +/- 0.25 lbs
- 8) FORMING PROCESS: a) HEAT SHEET TO 250°F
b) DRAPE OVER D3136-T1 MOLD AND CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

F	ADD D3136-5, D3136-045, DETAILS A/B/C, REVISE PART WEIGHTS	DB	14.12.10
E	REMOVE TRIM NOTE	DC	07.09.10
D	UPDATED MATERIAL NOTES	RF	05.12.01
C	ADDED FORMING AND ENGRAVING SPEC	KJ	04.05.05
B	ADDED D3136-3 AND D3136-043	RF	04.01.21
A	NEW ISSUE	DS	02.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	DB	DRAWING NO.	REV. F
MFG. APPR.	DB	D3136	SHEET 1 OF 3
APPROVED	DB	TITLE	SCALE
DE APPR.	DB	SPACEDOOR WINDOW	NTS
DATE	14.12.10	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

